

Date: Tuesday, 11/29/2005 7:11:18 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SPACER
Job Number	25056		Part Number	D30661
Estimate Number	10383		Drawing Number	D3066 REV. A
P.O. Number	N/A		Project Number	N/A
This Issue	11/29/2005 S.O. No. N/A		Drawing Revision	A
Prsht Rev.	NC		Material	N/A
First Issue	N/A		Due Date	11/29/2005
Previous Run	N/A		Qty:	120
Written By	<u>RF/KS</u>		Um:	Each
Checked & Approved By				
Comment	Created By Auto Work Order!!! Late - Some of the material cannot be made in time. <u>Rev C. 02-11-01</u>			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M5052H32S080	5052-H32 .080 Sheet
Comment: Qty.: 0.0992 sf(s)/Unit Total: 11.9070 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: <u>M19052</u>		
140 pcs		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 16.490" x 0.750" -0.000/+0.010" <u>J.L 05-12-12 +20</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA280 and Dwg D3065 Stack of 10 Identify as D3066-1		
<u>J.L 05-12-15 120</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.L 05-12-15 120</u>		
Tools: <u> </u>		

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 13366-1

PAR #: _____

Fault Category: Prod/machined

NCR: Yes NoDQA:

Date: 05/12/21

QA: N/C Closed:

Date: 05/12/21

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/14	3	-3 stacks of 10 scrap	J.C 05/12	- scrap + destroy - replace 1 stack of 10 to complete order of 120	J.CX 05/12/14	J.C 05/12/15	J.C 05/12/15	J.C 05/12/15

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 25056

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 05/12/15 120

Tools:

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

SAD 05/12/19 120

Tools:

7.0 QC5

INSPECT WORK TO CURRENT STEP



205-12-15

120

Comment: INSPECT WORK TO CURRENT STEP

Tools:

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 05/12/20 120

Tools:

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



205-12-20

120

Comment: INSPECT CHEMICAL CONVERSION COAT

Tools:

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

205-12-20

120

Tools:

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

05/12/21 120

Tools:

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

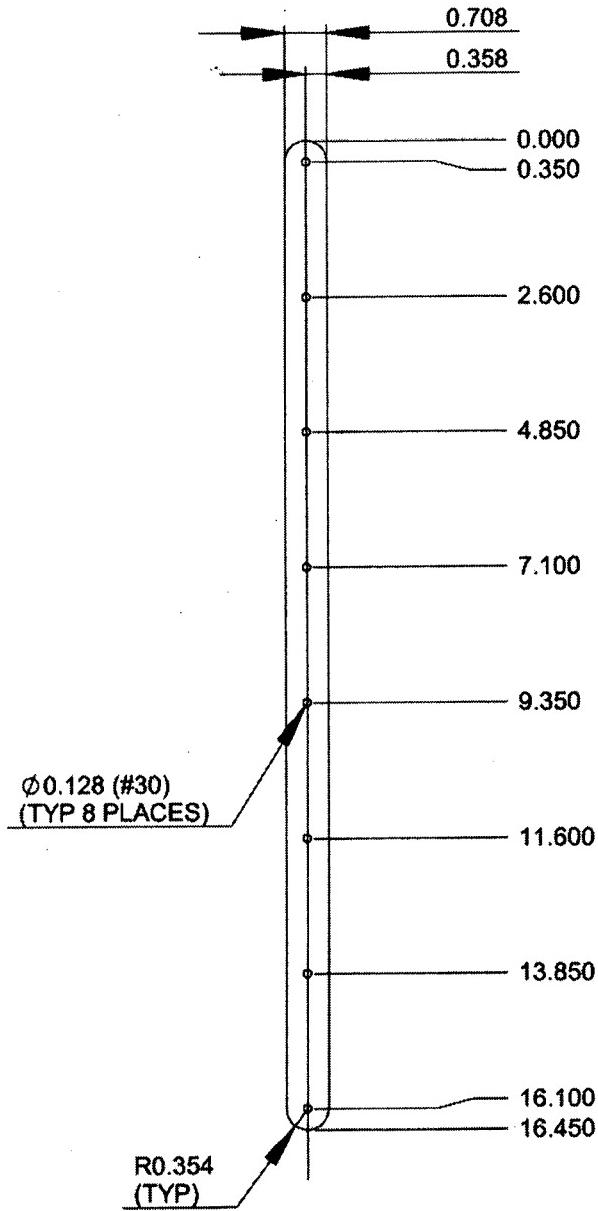
Measured by:	J.G	Audited by:	SD	Prototype Approval:	
Date:	05/12/14	Date:	05-12-14	Date:	

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF	

DART

COPY ISSUE

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SPACER	SCALE 1:3	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2009**D3066-1 SPACER**

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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